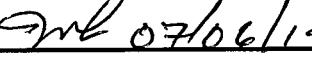
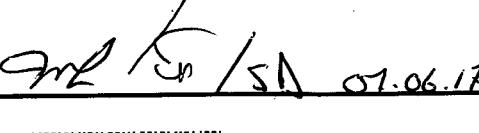
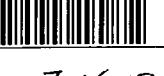
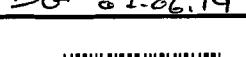
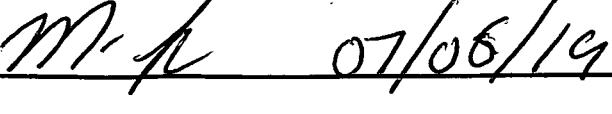


Date: Thursday, 5/10/2007 2:35:42 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	OUTER FWD SADDLE	
Job Number	32300			Part Number	D5951	
Estimate Number	11076			Drawing Number	D5951 REV.B	
P.O. Number	N/A			Project Number	N/A	
This Issue	5/10/2007	S.O. No.	N/A	Drawing Revision	B	
Prsht Rev.	NC			Material	N/A	
First Issue	N/A			Due Date	6/5/2007	
Previous Run	31528			Qty:	14	
Written By				Um:	Each	
Checked & Approved By	07/07/05. 10					
Comment	Est Rev:E	Re-Format	05-11-29	JLM		
	Est Rev:E	Re-Format	05-11-29	JLM		
Additional Product						
Job Number: 						
Seq. #:	Machine Or Operation:		Description :			
1.0	D6101013		Saddle billet 			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) D6101-013 (7075-T7351) Size 2.50" x 10.10" X 8.25" (Grain along 10.10") Batch: B25060  07/06/19 14						
2.0	HAAS3 		HAAS CNC VERTICAL MACHINING #3 			
Comment: HAAS CNC VERTICAL MACHINING #3 1-Machine as per folio D5951, Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble  07/06/19 17						
3.0	QC1 		INSPECT ALL DIM TO DIM SHEET 			
Comment: INSPECT ALL DIM TO DIM SHEET  07/06/19 17						
4.0	QC8 		SECOND CHECK 			
Comment: SECOND CHECK  BG 07-06-19						
5.0	HAND FINISHING1 		HAND FINISHING RESOURCE #1 			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1  M.K 07/06/19						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:35:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 32300

Part Number: D5951

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M 104144



(4)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL / M.R. 07-06-20

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(14)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CFS 07/06/21

8.0 PACKAGING 1

PACKAGING RESOURCE #1



(14)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 7/6/21 SP

(14)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

DOA/06/22

Job Completion



107/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	32300
Description: Outer Fwd Saddle				Part Number:	D5951
Inspection Dwg: D5951 Rev: B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.752	1.752	1.750		
C	5.245	5.255		5.250	5.252	5.251	5.250		
D	6.995	7.005		7.000	7.002	7.000	7.000		
E	5.745	5.755		5.749	5.750	5.750	5.750		
F	4.745	4.755		4.749	4.750	4.750	4.750		
G	0.312	0.319	315-322	0.320	0.320	0.320	0.320		
H	1.522	1.532		1.526	1.528	1.527	1.527		
I	3.048	3.058		3.053	3.055	3.054	3.054		
J	4.575	4.585		4.579	4.580	4.580	4.580		
K	0.312	0.319	315-322	0.320	0.320	0.320	0.320		
L	0.495	0.505		0.501	0.506	0.500	0.500		
M	0.490	0.510		0.502	0.500	0.499	0.502		
N	1.615	1.635		1.630	1.630	1.630	1.630		
O	7.990	8.010		7.996	7.998	8.003	8.001		
P	2.240	2.260		2.257	2.257	2.257	2.257		
Q	0.307	0.312		0.309	0.309	0.310	0.309		
R	0.760	0.765		0.765	0.765	0.765	0.765		
S	0.490	0.510		0.504	0.495	0.497	0.499		
T	1.375	1.395		1.390	1.387	1.387	1.389		
U	2.000	2.020		2.007	2.008	2.017	2.009		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	Mark Fer / SA
Date:	07/06/14

Audited by:	BC
Date:	07-06-14

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	E

DART AEROSPACE LTD	Work Order:	32300
Description: Outer Fwd Saddle	Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.437	0.444		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.001	7.000	7.001	6.999		
E	5.745	5.755		5.750	5.751	5.751	5.750		
F	4.745	4.755		4.752	4.749	4.751	4.750		
G	0.312	0.319	.315 → .322	.320	.320	.320	.320		
H	1.522	1.532		1.527	1.527	1.527	1.528		
I	3.048	3.058		3.054	3.057	3.054	3.054		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.312	0.319	.315 → .322	.320	.320	.320	.320		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.499	.501	.498	.499		
N	1.615	1.635		1.630	1.630	1.630	1.630		
O	7.990	8.010		8.001	8.002	8.000	8.000		
P	2.240	2.260		2.257	2.257	2.252	2.257		
Q	0.307	0.312		0.309	0.309	0.309	0.309		
R	0.760	0.765		.765	.765	.765	.765		
S	0.490	0.510		.497	.497	.497	.497		
T	1.375	1.395		1.386	1.387	1.387	1.387		
U	2.000	2.020		2.006	2.067	2.008	2.007		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EN / SA	Audited by:	SG
Date:	07/06/17	Date:	07-06-19

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	EZ

DART AEROSPACE LTD				Work Order:	32300
Description: Outer Fwd Saddle				Part Number:	D5951
Inspection Dwg: D5951 Rev: B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.437	0.444		.439	.435	.438	.439		
B	1.745	1.755		1.750	1.750	1.751	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.25		
D	6.995	7.005		6.999	6.991	6.998	7.000		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.312	0.319	315-322	320	320	320	320		
H	1.522	1.532		1.527	1.527	1.528	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.312	0.319	315-322	320	320	320	320		
L	0.495	0.505		500	497	500	500		
M	0.490	0.510		497	493	494	495		
N	1.615	1.635		1.630	1.631	1.630	1.631		
O	7.990	8.010		7.998	7.998	8.000	7.998		
P	2.240	2.260		2.250	2.250	2.250	2.253		
Q	0.307	0.312		309	309	309	309		
R	0.760	0.765		762	762	762	762		
S	0.490	0.510		498	497	498	498		
T	1.375	1.395		1.382	1.388	1.387	1.388		
U	2.000	2.020		2.002	2.008	2.007	2.008		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by:	
Date:	07-06-18	Date:	07-06-18

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	

DART AEROSPACE LTD	Work Order:	32300
Description: Outer Fwd Saddle	Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		0.440	0.440				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.745	5.755		5.748	5.750				
F	4.745	4.755		4.747	4.750				
G	0.312	0.319	315>322	0.320	0.320				
H	1.522	1.532		1.526	1.526				
	3.048	3.058		3.053	3.059				
J	4.575	4.585		4.580	4.580				
K	0.312	0.319	315>322	0.320	0.320				
L	0.495	0.505		0.499	0.499				
M	0.490	0.510		0.498	0.501				
N	1.615	1.635		1.635	1.635				
O	7.990	8.010		7.998	7.998				
P	2.240	2.260		2.260	2.260				
Q	0.307	0.312		0.310	0.310				
R	0.760	0.765		0.760	0.766				
S	0.490	0.510		0.498	0.502				
-	1.375	1.395		1.380	1.387				
U	2.000	2.020		2.008	2.008				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD Pnd
Date:	07.06.18

Audited by:	BC
Date:	07.06.19

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
E	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	BC

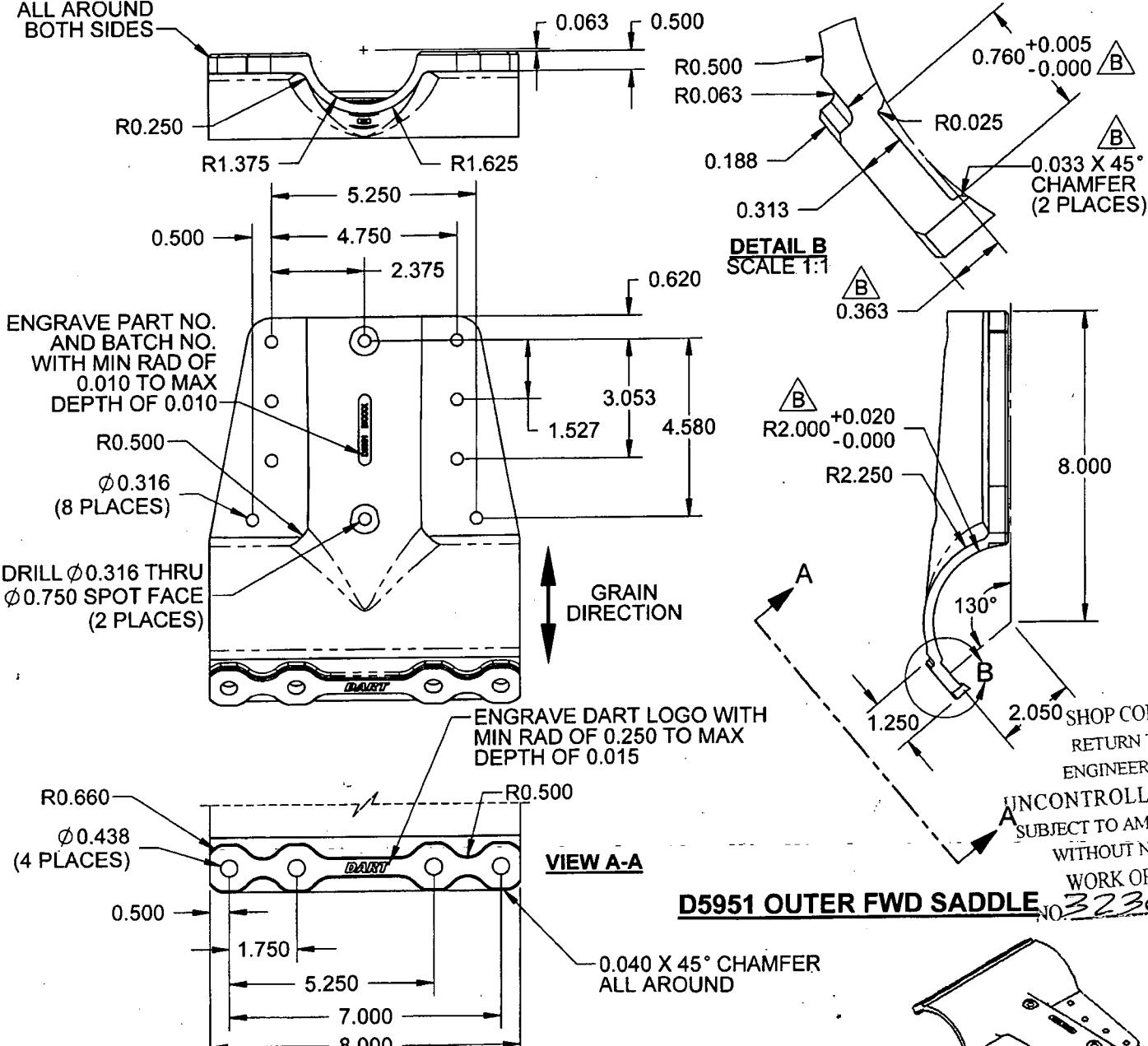
DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D5951	REV. B SHEET 1 OF 1
DATE 06.11.07		TITLE OUTER FWD SADDLE	SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
REV B	DATE 06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;	

RELEASED BY

06.11.28

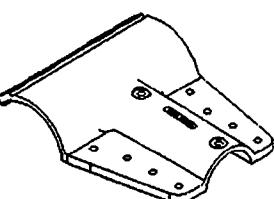
CHAMFER
0.075 X 45°
ALL AROUND
BOTH SIDES



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

A
B
R2.000 +0.020 -0.000
R2.250
1.250
2.050
130°
GRAIN DIRECTION
ENGRAVE DART LOGO WITH
MIN RAD OF 0.250 TO MAX
DEPTH OF 0.015
VIEW A-A
0.040 X 45° CHAMFER
ALL AROUND
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32300



ISOMETRIC VIEW
SCALE 1:8